












Date: Friday, 28/09/2007 2:56:27 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3245-2 PREL
Job Number	: 34910	Part Number	: D3245042
Estimate Number	: 10804	Drawing Number	: ECN 1040P
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 28/09/2007 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: 28/09/2007 Type : SMALL /MED FAB	Due Date	: 05/10/2007
Previous Run	: 34907	Qty:	2 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	:		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S22GA	304/316 .032 Sheet	
			
Comment: Qty.: 0.8442 sf(s)/Unit Total : 1.6884 sf(s) 304/316 .032 Sheet Batch: <u>M105262</u> <u>IB 07-10-1</u>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3245 ****prog.D3245-1/-2**** Dwg Rev B per ECN 1040P Prog Rev: <u>PRE L</u> <u>IB 07-10-1</u> 2-Deburr if necessary <u>IB 07-10-1</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 07-10-1</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK ENGINEERING APPROVAL <u>07.10.01</u> <u>En 09/10/01 (82)</u>			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Deburr if necessary C'sink as per Dwg D3245 Form D3245-1 as per Dwg D3245 Identify as D3245-1 <u>MF 07-10-02</u>			

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3245-2 PREL

Job Number: 34910

Part Number: D3245042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 071003 (2)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
ASSEMBLE PER DRWG

mf 07-10-03 (2)

8.0

235018C3Y

RIGID RECEPTACLE



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)
RIGID RECEPTACLE

m17648 x 10mv, m105784 x 6mx

mf

9.0

MS20427M33

Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)
Rivet

m102328

mf 07-10-03 (2)

(P10) (2)
Last page

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 071003 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
-Location: _____

C 7/10/04 (2)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(2)
Don 10/04

Job Completion



U 07.10.04

POSITIVE RECALL

EFFECTIVE 07.10.01

AUTH

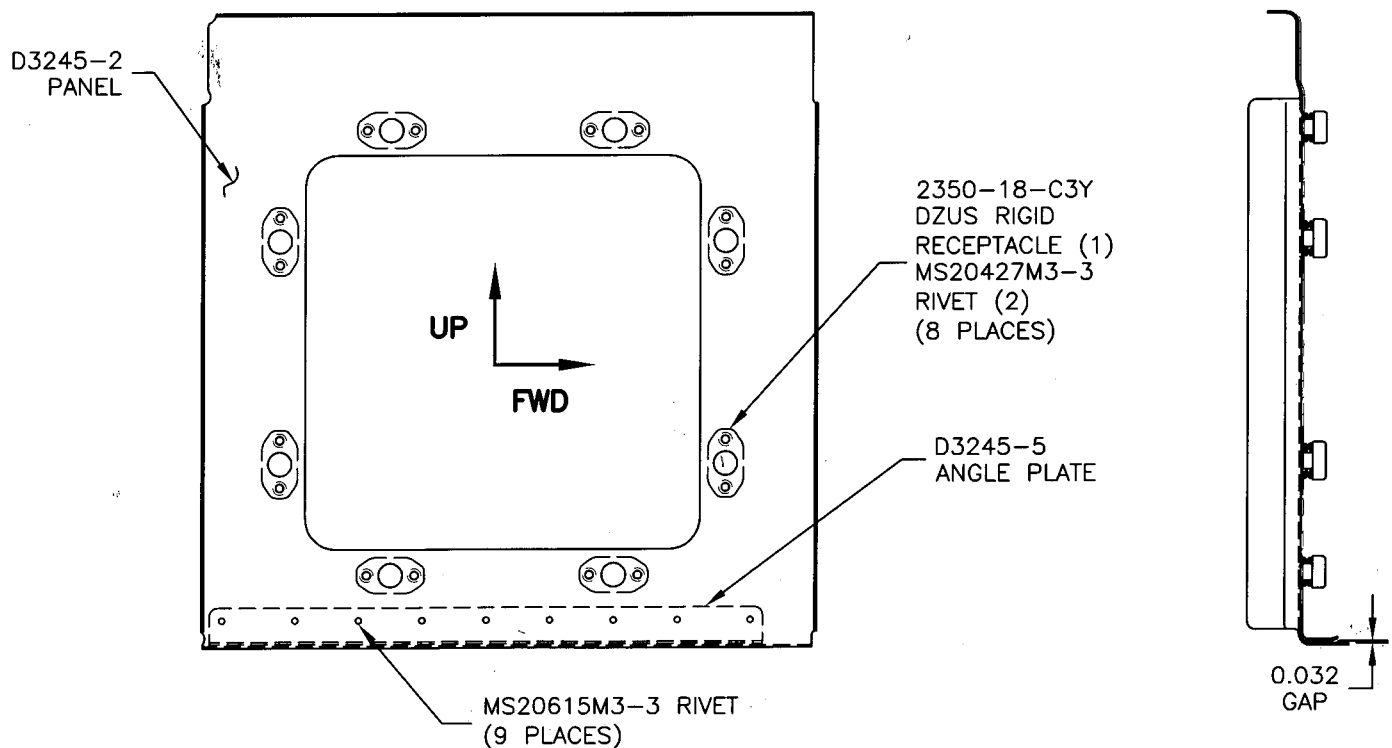
RELEASED 07.10.04

DATE

PRELIMINARY ISSUE

07.09.26

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3245	REV. B SHEET 2 OF 6
DATE 07.09.26		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3



D3245-042 ACCESS PANEL ASSEMBLY

D3245-042 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 5) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

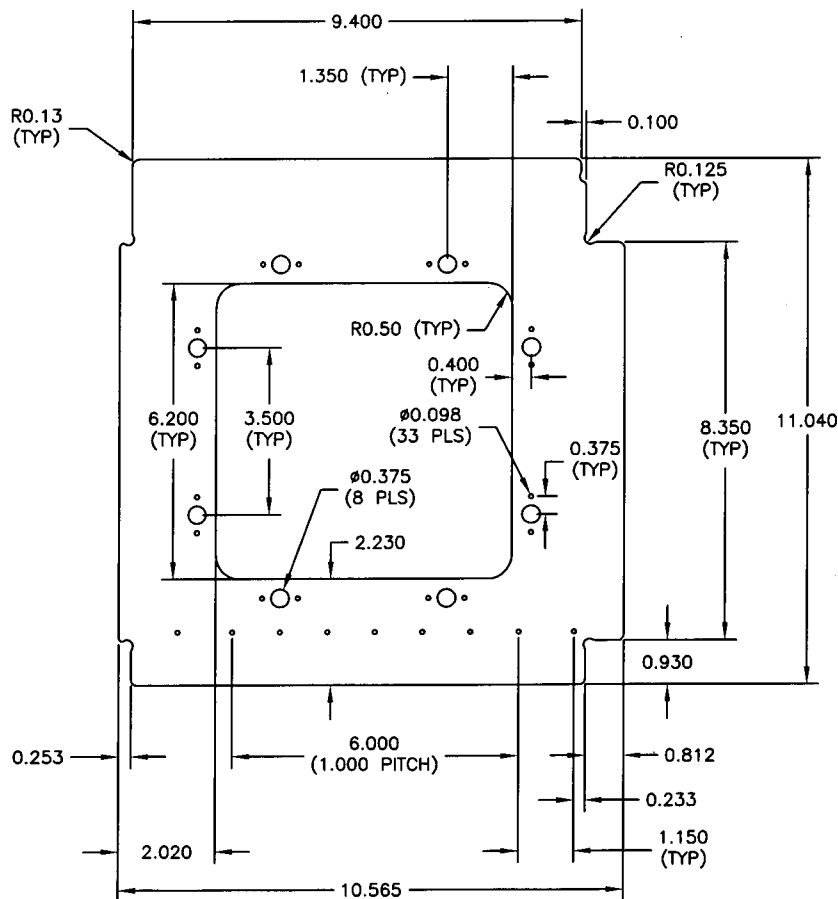
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PRELIMINARY ISSUE

07.09.25

DESIGN RF	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3245	REV. B SHEET 4 OF 6
DATE 07.09.26	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4



D3245-1/-2 PANEL FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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BART AEROSPACE LTD		Work Order:	34910
Description: ACCESS PANEL ASSEMBLY		Part Number:	D3245-2
Inspection Dwg: D3245-2 Rev: PRE L		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .375	+ .006 - .001	.375				
Ø .098	+ .004 - .001	.099				
9.400	+/- .010	9.400	*			
1.350	+/- .010	1.350	*			
.100	+/- .010	.105	*			
11.040	+/- .010	11.040	*			
8.350	+/- .010	8.350	*			
.930	+/- .010	.931	*			
10.565	+/- .010	10.565	*			
6.000	+/- .010	6.000	*			
.812	+/- .010	.814	*			
.233	+/- .010	.233	*			
1.150	+/- .010	1.150	*			
.253	+/- .010	.252	*			
2.020	+/- .010	2.024	*			
2.230	+/- .010	2.230	*			
6.200	+/- .010	6.202	*			
.375	+/- .010	.375	*			
.400	+/- .010	.400	*			
3.500	+/- .010	3.500	*			
R .125	+/- .010	.125	*			
R .13	+/- .030	.13	*			
R .50	+/- .030	.50	*			

Measured by: <i>HB</i>	Audited by: <i>EN</i>	Prototype Approval: <i>13</i>
Date: 07-10-01	Date: 07/10/01	Date: 07.10.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/03	2 9.1	ADD step for installing D3245-5 (angle Plate)	St	07/10/03			En 07/10/03
07/10/03		D3245-5 Batch # <u>B23260x1mx</u> , B34607. MS20615 m3-3 Rivet x9.000 Batch # <u>M17654</u>	mf	07/10/03	2		En 07/10/04

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries